

Date: Wednesday, 30/04/2008 10:23:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 38905		
Estimate Number	: 12716		
P.O. Number	:	Part Number	: D353635
This Issue	: 30/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3536 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 38183	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 09/05/2008
Checked & Approved By	: <u>JLD 08.4.30</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6507 sf(s)/Unit Total: 13.0137 sf(s)
 NEOPRENE SHEET 0.063

Batch: 107655 IB 8-5-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: A
 Prog Rev: A

IB 8-5-2

26

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-2

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S o s l o s t o r 26

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP6

8/5/2

26
SIP

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 10:23:20 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38905

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-05

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38905
Description: Gasket		Part Number: D3536-35
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	X			
19.75	+/-0.030	19.75	X			
17.75	+/-0.030	17.75	X			
14.25	+/-0.030	14.25	X			
9.50	+/-0.030	9.50	X			
4.75	+/-0.030	4.75	X			
2.00	+/-0.030	2.00	X			
6.00	+/-0.030	6.00	X			
6.75	+/-0.030	6.75	X			
0.30	+/-0.030	.303	X			
0.30	+/-0.030	.303	X			
1.89	+/-0.030	1.892	X			
Ø0.19	+0.005/-0.001	.195	X			
0.063	+/-0.010	.059	X			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-5-2	Date: 08/05/02	Date:	N/A

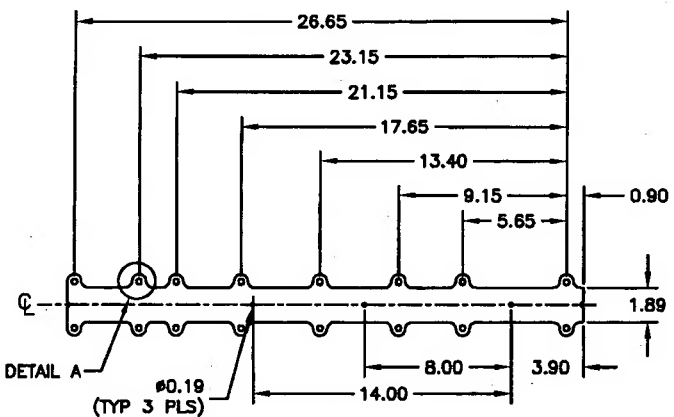
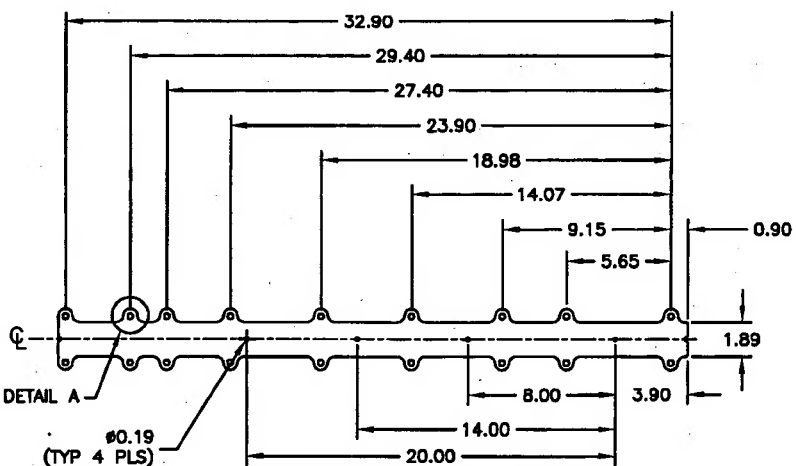
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM [Signature]	[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED AH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE	SCALE 1:10

RELEASED

09.02.12-1

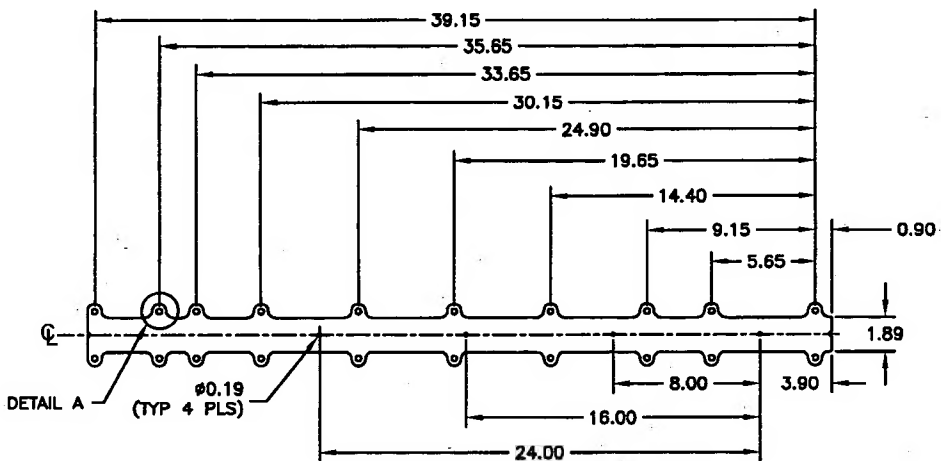
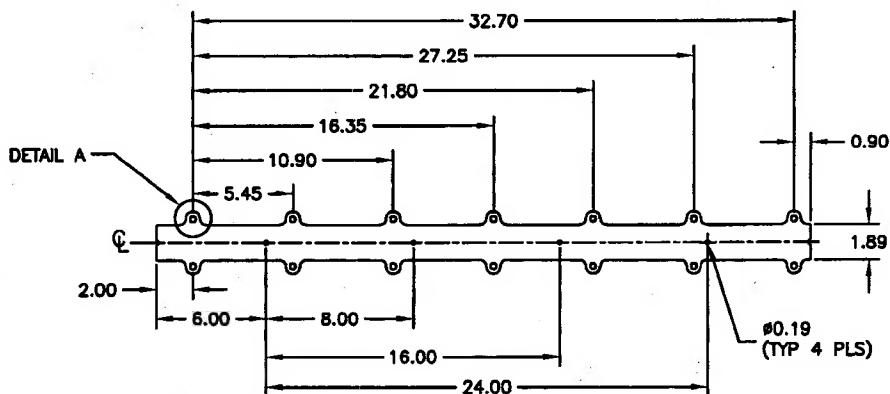
**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WITHOUT NOTICE
WORK ORDER
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C.B.	C.B.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
M		D3536	SHEET 2 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	

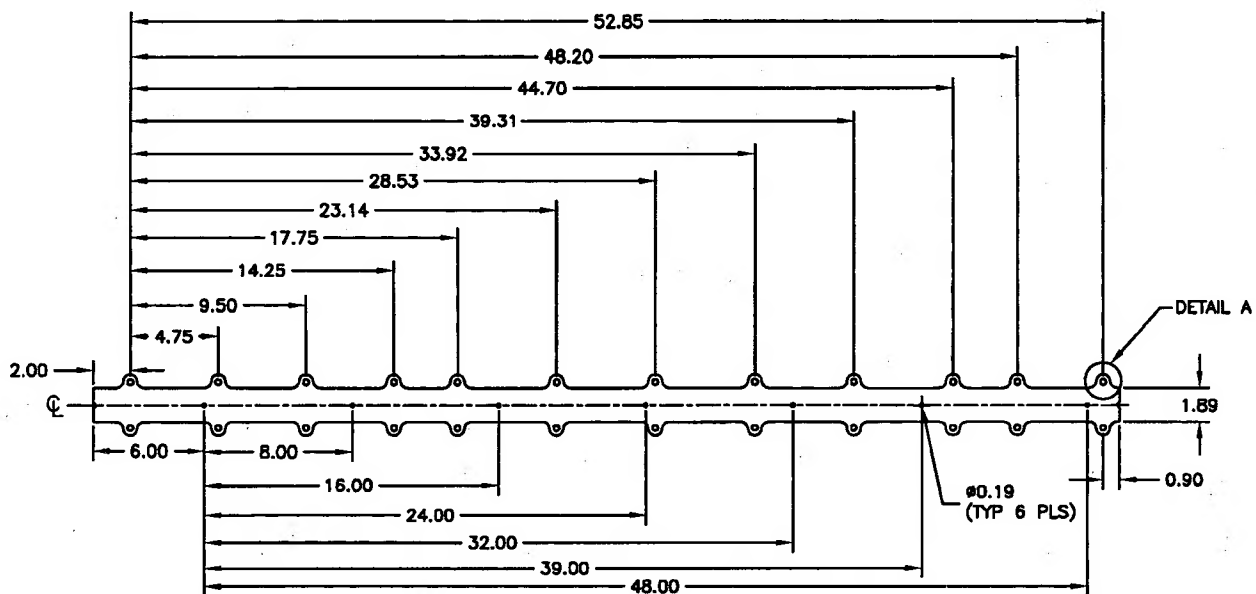
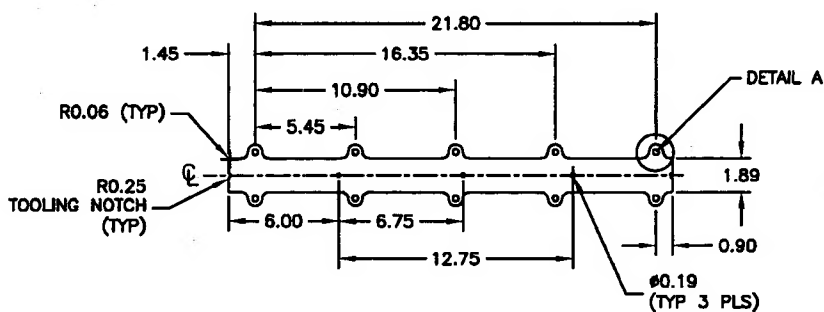
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07.02.12**D3536-15 GASKET****D3536-21 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 6
PH	PH	D3536	
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	

RELEASED
07.02.12**D3536-23 GASKET****D3536-25 GASKET****NOTES**

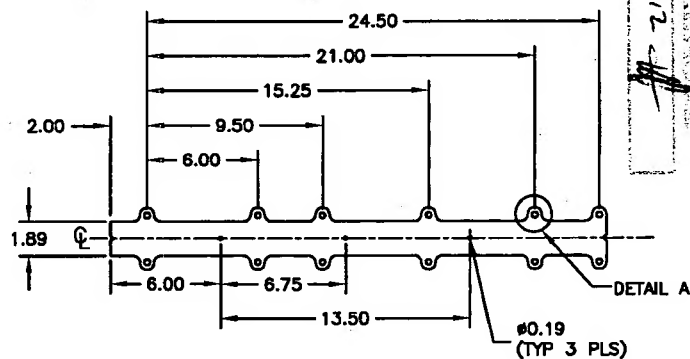
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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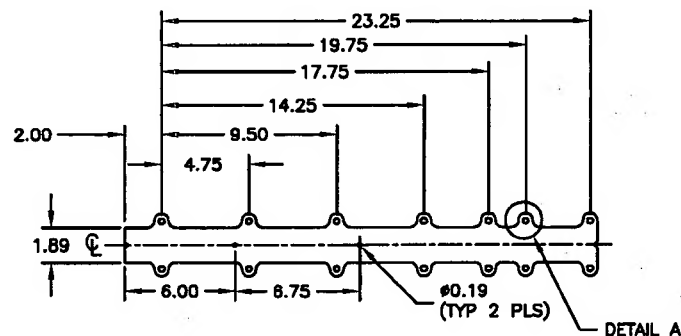
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

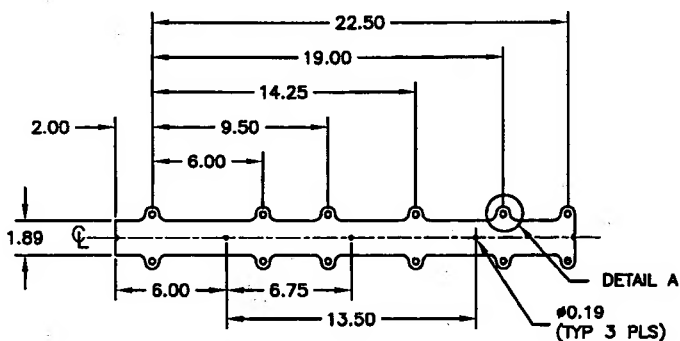
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

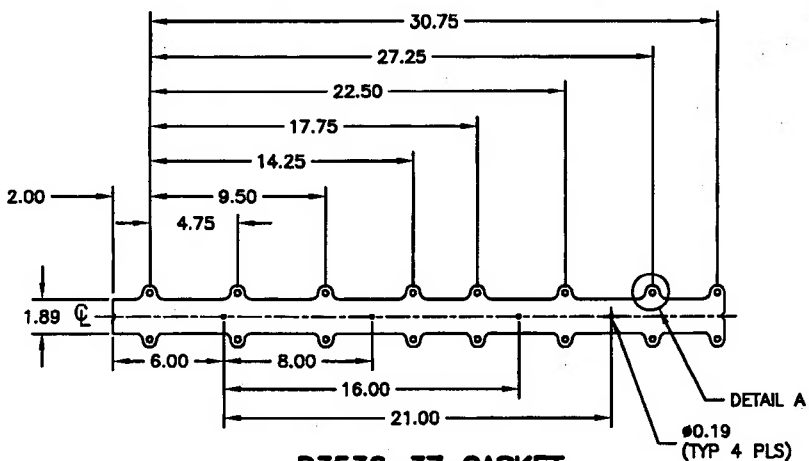
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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE
				1:10

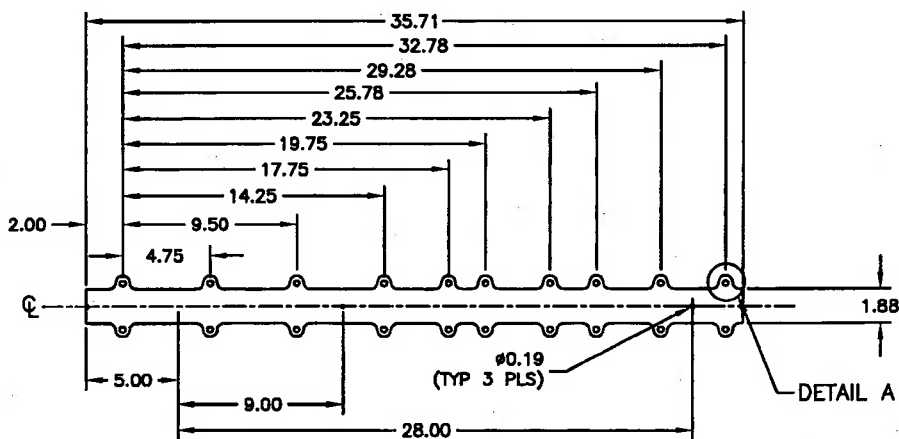
07.02.02
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**D3536-37 GASKET**

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NOTES

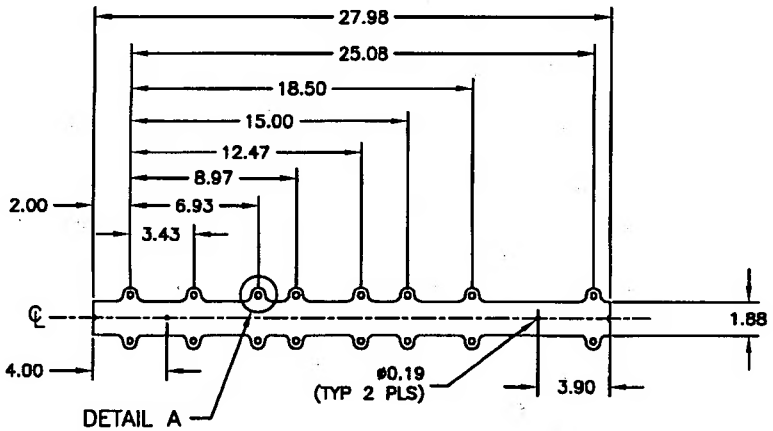
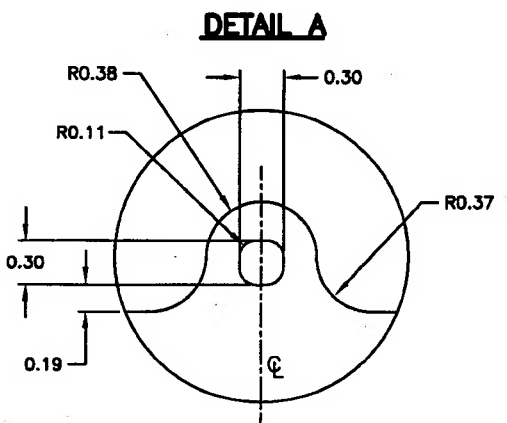
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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**D3536-39 GASKET**

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07 JUL 02

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DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10



D3536-41 GASKET

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